

Work Order ID 129619

February-20-15 8:03:00 AM

129619

Page 1

Item ID: D4012-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Cushion

Start Date: 2/20/15 Start Qty: 8.00

Required Date: 2/24/15 Req'd Qty: 8.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4012

B

100

0.00

100

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Mill as per folio FA889

Folio rev: AA

Dwg. rev: AB

17

φ

JFC 2015-02-22

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

17

φ

JFC 2015-02-22

Work Order ID 129619

129619

Page 2

February-20-15 8:03:00 AM

Item ID: D4012-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cushion
 Start Date: 2/20/15 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 2/24/15 Req'd Qty: 8.00 *8* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							DAS 08 9-89
Quality Control									

123		0.00							
123									
Small Fab	Memo	0.00							
Small Fab	CLAMP AND FORM CUSHION AS PER DWG BY SLIGHTLY HEATING IT WITH HEAT GUN, LET IT COOL DOWN BEFORE REMOVING CLAMP.								

126	QC5- Inspect part completeness to step on W/O	0.00							
126									
QC	Memo	0.00							
Quality Control									

DAS
36
9-89

February-20-15 8:03:00 AM

Item ID: D4012-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Cushion

Stop *NS2*

Start Date: 2/20/15 **Start Qty:** 8.00

8

Cust Item ID:

Required Date: 2/24/15 **Req'd Qty:** 8.00

8

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run	Start	*NR1*
	Stop	*NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

130

Identify as per dwg & Stock Location: TS45

0.00

130

Packaging

Memo

0.00

Packaging

**DAS
66
9-89**

17
FEB 23 2015

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

15/2/23

ME
15-2-23

Picklist Print

February-20-15 8:02:59 AM

Page 1

Work Order ID: 129619

129619

Parent Item: D4012-1

D4012-1

Parent Item Name: Cushion

Start Date: 2/20/15

Required Date: 2/24/15

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP RevA: New issue 09.10.28 DD verified by:JLM
revA as per dwg 09.11.18 DD verified by:JLM
as per dwg Rev.B DD verified by:JLM

IPP RevB:
IPP Rev:C 11.01.10

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4287-3		Manufactured	No			100	f	5.6930	0.37	4			
										**			

D4287-3

Uhmw U-Channel

Location

ST479a

122488

Loc Qty

5.693

5.693

Loc Code

15-02-20

~~5.69~~ 5.69

29619

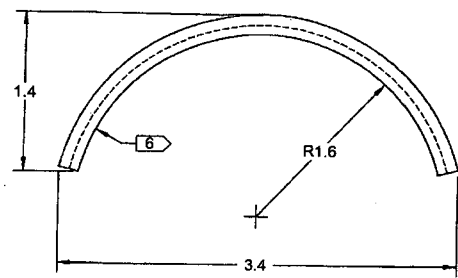
FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

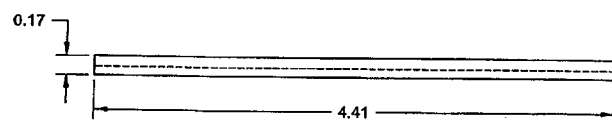
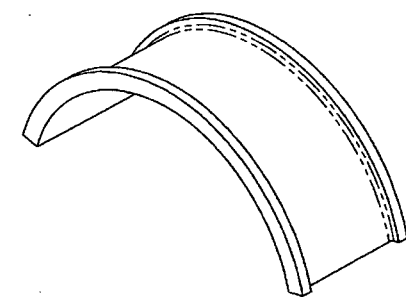
Measured by: JFC	Audited by: J.A.	DAS	Preliminary Approval:
Date: 2015-02-22	Date: 15/02/23	08 9-89	Date:

Rev	Date	Change	Revised by	Approved
A	11.01.17	New Issue	KJ	
B	12.08.02	Dwg Rev updated	KJ	

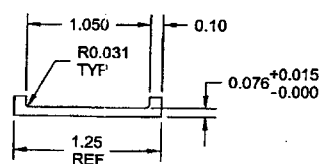
wlo 129619



D4012-1 CUSHION
 (MAKE FROM D4012-1F)



D4012-1F FLAT MACHINED STATE



RELEASED
 2010-12-23
 JMB

- NOTES:**
- 1) MATERIAL: MAKE FROM D4287-3
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4012-1" AND B/N "BXXXXX" PER QSI 044 6.1
 - 7) WEIGHT: 0.02 lbs

B	CHANGED RAW MATERIAL TO REDUCE MANUFACTURING COSTS; PART NOW MACHINED FLAT AND SHAPED WITH RADIUS. REF: PAR10-29	MB	10.12.07
A	NEW ISSUE	MB	09.10.19
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.07		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4012	REV. B
TITLE CUSHION	SHEET 1 OF 1
	SCALE NTS

COPYRIGHT © 2009 BY DART AEROSPACE LTD
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.